

Work Order ID 94453

94453

Page 1

December-19-12 11:07:55 AM

Item ID: D350-616-015

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Deck Plate

Start Date: 12/19/12 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12-12-12 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D350-616	E
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100

0.00

100

DC

Document Control

Memo

Photocopy bluefile and create labels per PPP D350-616-015
CHG002

0.00

DAS 16 13/3/5

13-3-4 (3)

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

13/3/5 (3)

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

DAS 16 13/3/5

(+3)

DAS 16 13/3/5

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 94453

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Page 2

December-19-12 11:07:55 AM

Item ID: D350-616-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Deck Plate

Start Date: 12/19/12 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-616-015								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten stamp: DAS 06 8-83

Handwritten note: PPP 94520

Handwritten date: 13/3/8

Handwritten date and signature: 13/3/6

Handwritten note: 113-035

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

December-19-12 11:07:53 AM

Page 1

Work Order ID: 94453

Parent Item: D350-616-015

Parent Item Name: Deck Plate

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:C Removed Manufacturing 05-12-05 JLM
 IPP Rev:D Add D3494-1 05-12-05 JLM
 IPP rev E added parts per NCR 08-041 08.04.30 EC verified by: DD
 IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S B AN960JD10 Washer	NAS1149D0363J	Purchased	No			110	Each	0.0000	10	30		12/3/12	
S B D2344 Litter Deck Plate, 350		Manufactured	No			110	Each	7.0000	10	3		9/5/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST220a		7							
				89132		7							
S B D2348 Wearplate		Manufactured	No			110	Each	30.0000	4	12		9/4/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		30							
				89129		30							
S B D2353 Stiffener		Manufactured	No			110	Each	4.0000	11	3		9/4/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST220.		4							
				89209		4							
S B D2364 Deck Plate, Fwd 350 Litt		Manufactured	No			110	Each	7.0000	10	3		9/5/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST220a		7							
				89094		7							
S B D2365 Wearplate		Manufactured	No			110	Each	28.0000	2	6		9/5/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		28							
				89065		28							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Picklist Print

December-19-12 11:07:54 AM

Page 2

Work Order ID: 94453

Parent Item: D350-616-015

Parent Item Name: Deck Plate

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 3.00

Required Qty: 3.00

D2369-1
Deck Plate Locator Brackets

Manufactured No

110 Each 14.0000

0

3

95672

Location

Loc Qty

Loc Code

ST241A

14

89158

14

D2369-3
Deck Plate Locator Brackets

Manufactured No

110 Each 11.0000

U

3

95673

Location

Loc Qty

Loc Code

ST241A

11

89414

11

D3494-1
Stub Cover

Manufactured No

110 Each 5.0000

U

395031

Location

Loc Qty

Loc Code

ST220a

5

88301

5

MS20426AD4-5
Rivet

Purchased No

110 Each 2,739.0000

25

75

Location

Loc Qty

Loc Code

GA

73

6874

73

ST317

2666

6874

2666

MS20426AD4-6
Rivet

Purchased No

110 Each 2,188.0000

25

75

Location

Loc Qty

Loc Code

GA

1765

122814

1765

ST334

423

121708

423

December-19-12 11:07:54 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Picklist Print

December-19-12 11:07:54 AM

Page 3

Work Order ID: 94453
 Parent Item: D350-616-015
 Parent Item Name: Deck Plate

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 3.00

Required Qty: 3.00

MS20426AD5-7
 Rivet

Purchased No

110 Each 1,027.0000

6

18

Location

Loc Qty

Loc Code

ST334

1027

101340

1027

MS20426AD5-8
 Rivet

Purchased No

110 Each 1,047.0000

6

18

Location

Loc Qty

Loc Code

ST334

1047

4533

1047

MS20601-AD4W2
 Rivet

Purchased No

110 Each 61.0000

15

45

Location

Loc Qty

Loc Code

ST311

61

122539

11

123900

50

MS20601-AD4W3
 Rivet

Purchased No

110 Each 57.0000

30

90

Location

Loc Qty

Loc Code

ST311

57

114538

57

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY				
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Picklist Print

December-19-12 11:07:54 AM

Page 4

Work Order ID: 94453

Parent Item: D350-616-015

Parent Item Name: Deck Plate

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 3.00

Required Qty: 3.00

MS21042L3

Purchased

No

110

Each

4,778.0000

6

18

Nut

Location

Loc Qty

Loc Code

FP001

143

122141

143

GA

458

122452

458

ST314

677

117885

32

119017

55

119075

138

123265

452

ST506

3500

123900

3500

MS24693-C273

Purchased

No

110

Each

170.0000

6

18

Screw

Location

Loc Qty

Loc Code

ST300

170

122539

170

MS24693-C48

Purchased

No

110

Each

110.0000

22

66

Screw

Location

Loc Qty

Loc Code

ST300

110

122993

35

123900

75

MS35207-264

Purchased

No

110

Each

92.0000

4

12

Screw

Location

Loc Qty

Loc Code

ST289

92

123352

92

December-19-12 11:07:54 AM

Shop Packet Print

Page 4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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REFERENCE ONLY

QTY - 011	Qty - 013	Qty - 015	Part Number	Description
X			D350-616-011	Full Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
	1	X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
		1	D2353	STIFFENER
	1		D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
1			D2370	LITTER ASSEMBLY
1			D2493	PATIENT STOP
	1		D3179-041	LITTER TIE DOWN (NON-LOCKING)
		1	D3494-1	STUB COVER
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (or CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (or CR9162-4-3)
		6	MS21042L3	NUT (or MS21042-3)
		6	MS24693-C273	SCREW (or MS24693-273)
		22	MS24693-C48	SCREW (or MS24693-48)
		4	MS35207-264	SCREW
		10	NAS1149D0363J	WASHER (or AN960JD10)

RELEASED
08/11/21

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: D. SHEPHERD (DE # 02)

DATE: 08.11.07
CERT. NO.: SH96-10
ISSUE NO.: 2

E	MAKE DSI 9310 STANDARD; D3179-041 REPLACES D2350	RF	08.11.07
D	ADD D3494-1 STUB COVER	MB	06.01.19
C	ADD DSI 9112/9117/9130/9236/9310	MB	06.01.10
B	ADD VIEW OF D2493 TO SHEET 9	BW	96.01.09
A	NEW ISSUE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D350-616	SHEET 1 OF 12
APPROVED	DS	TITLE	SCALE
DE APPR.		AS350/355 LITTER KIT INSTALLATION	NTS
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